

Date: Wednesday, 5/31/2006 7:41:00 AM
 User: Kim Johnston

Process Sheet

26

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW KIT (19"X48")
 Job Number : 27314
 Estimate Number : 10768
 P.O. Number : NIA Part Number : K10015
 This Issue : 5/31/2006 S.O. No. : NIA Drawing Number : D2521 REV I
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : MACHINED PARTS Drawing Revision : 1
 Previous Run : 25768 Material : NIA
 Written By : See in comment below Due Date : 6/30/2006 Qty: 12 Um: Each
 Checked & Approved By : 06.05.31
 Comment : Est Rev:D 05.06.20 Forming removed KJJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile:
 K10015
 D205-564-011
 D430-688-011
 and create labels per PPP K10015: CHG002
 (Bag Bluefiles separately)

KS 06.06.19

12

2.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 13.6500 sf(s)/Unit Total : 136.5000 sf(s)
 blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: M100501 / 7 pcs M101627 / 17 pcs D101627 / 17 pcs J.F. 06/07/20

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

(2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2432F

3-Deburr

M101627 / 17 pcs J.F. 06/07/20

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr.	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:41:00 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X48")

Job Number: 27314

Part Number: K10015

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/07/20 12

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/07/28 x 12

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

7.0

D2182B055

Clamp Cushion, Black



Comment: Qty.: 8.0000 Each(s)/Unit Total: ~~80~~ 96.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 D2182B055 Rubber Cushion B24870 X 93 / B 28042 X 3 c2

8.0

D2274

Radius Block



Comment: Qty.: 16.0000 Each(s)/Unit Total: ~~160~~ 192.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
16 D2274 Radius Block B26520 X
2 D2521(ref only) Bearpaw B27314

9.0

D2529

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: ~~160~~ 192.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
16 D2529 Washer B26485 B26485 X

10.0

D2947

Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total: ~~80~~ 96.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 D2947 Clamp B21588 X 16 mcp B23188 25 mcp X

B25770 55 mcp X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/07/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:41:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X48")

Job Number: 27314

Part Number: K10015

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN415A

Bolt



192



Comment: Qty.: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN4-15A

Bolt

M19085

188mc ✓

M19185 4mc ✓

12.0

AN960JD416

Washer



192



Comment: Qty.: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M101369 ✓

13.0

MS21042L4

Nut



192



Comment: Qty.: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 MS21042L4

Nut (or -4)

M19085 ✓

P 6/1/26

(12)

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AP 06/07/26

(12)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10015

Location:

Rev-D

AP 06/07/26

(12)

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AP 06/07/27

(12)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27314
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521		Rev: I	Page 1 of 1

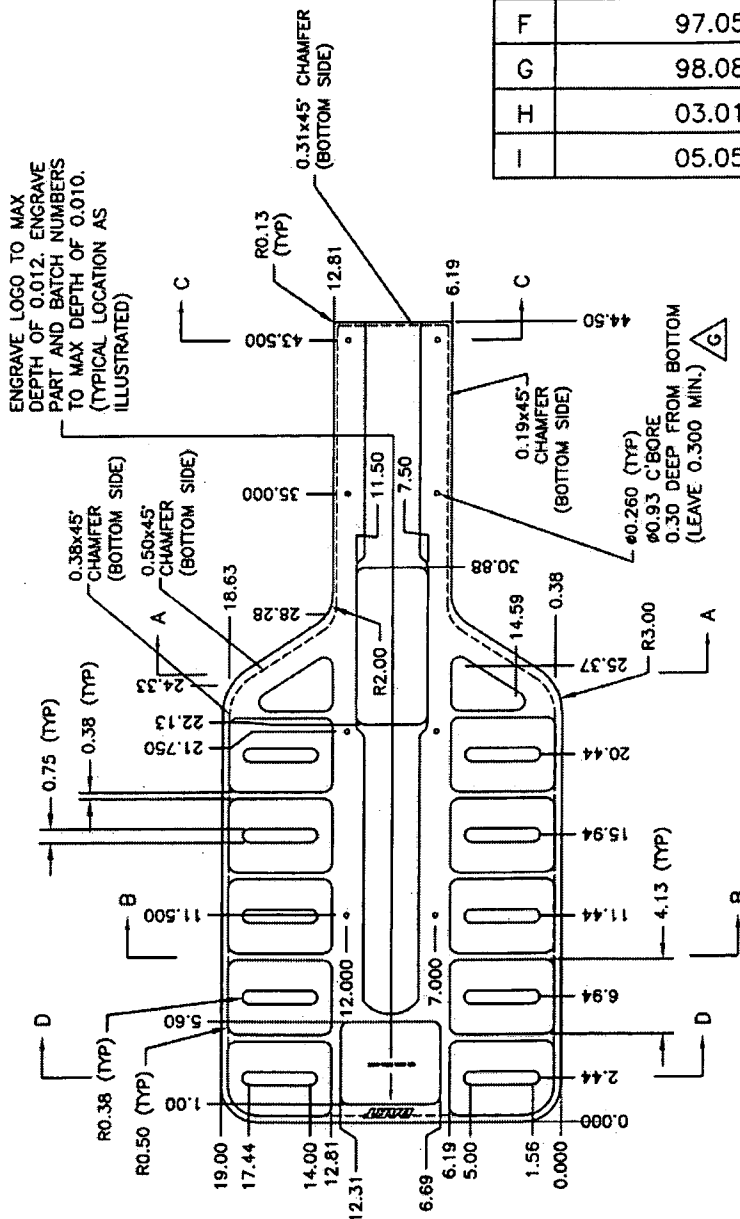
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.00	+/-0.030	1.000	/			
B	5.60	+/-0.030	5.60	/			
C	11.50	+/-0.030	11.50	/			
D	10.250	+/-0.010	10.250	/			
E	13.250	+/-0.010	13.250	/			
F	8.500	+/-0.010	8.500	/			
G	22.13	+/-0.030	22.13	/		Tape	
H	8.75	+/-0.030	8.75	/			
I	44.50	+/-0.030	44.50	/		Tape	
J	6.69	+/-0.030	6.69	/			
K	5.63	+/-0.030	5.63	/			
L	7.000	+/-0.030	7.000	/			
M	5.000	+/-0.010	5.000	/			
N	4.00	+/-0.030	4.00	/			
O	6.63	+/-0.030	6.632	/			
P	19.00	+/-0.030	19.00	/		Tape	
Q	0.31 x 45°	+/-0.030	.330 x 45°	/			
R	0.19 x 45°	+/-0.030	.200 x 45°	/			
S	0.50 x 45°	+/-0.030	.510 x 45°	/			
T	0.38 x 45°	+/-0.030	.400 x 45°	/			
U	0.063 x 45°	+0.030/-0.010	.060 x 45°	/			
V	Ø0.260	+0.005/-0.000	.260	/			
W	Ø0.93	+/-0.030	.928	/			
X	0.30	+0.030/-0.010	.305	/			
Y	0.37	+0.030/-0.010	.380	/			
Z	0.75	+0.030/-0.010	.760	/			
AA	0.25	+0.030/-0.010	.260	/			
AB	4.00	+/-0.030	4.002	/			
AC	6.62	+/-0.030	6.635	/			
AD	0.95	+0.030/-0.010	.957	/			
AE	0.37	+0.030/-0.010	.380	/			
AF	3.40	+0.030/-0.010	3.390	/			
AG	6.63	+/-0.030	6.630	/			

Measured by:	SD	Audited by:	Ep	Prototype Approval:	N/A
Date:	06.07.19	Date:	06/07/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10015	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	

DART**RELEASED**
05-06-13

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2521	REV. 1 SHEET 1 OF 2
DATE 05.05.20	TITLE 205 BEARPAW		SCALE 1:10
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	





NOTES:
1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES

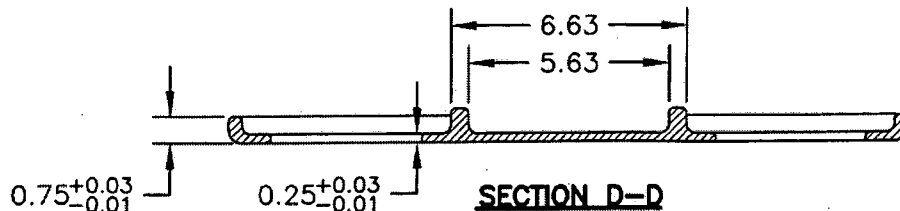
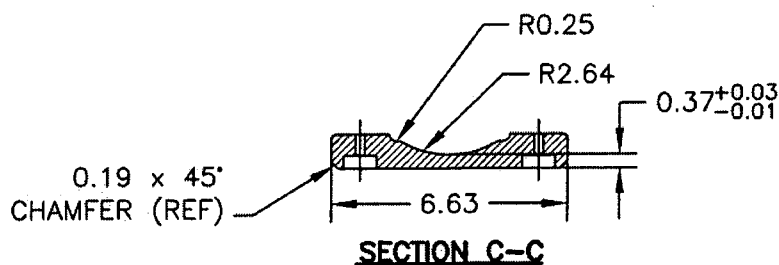
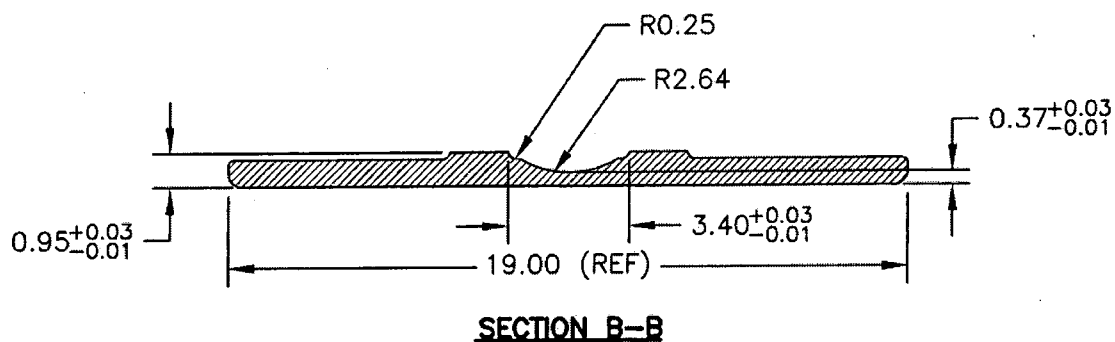
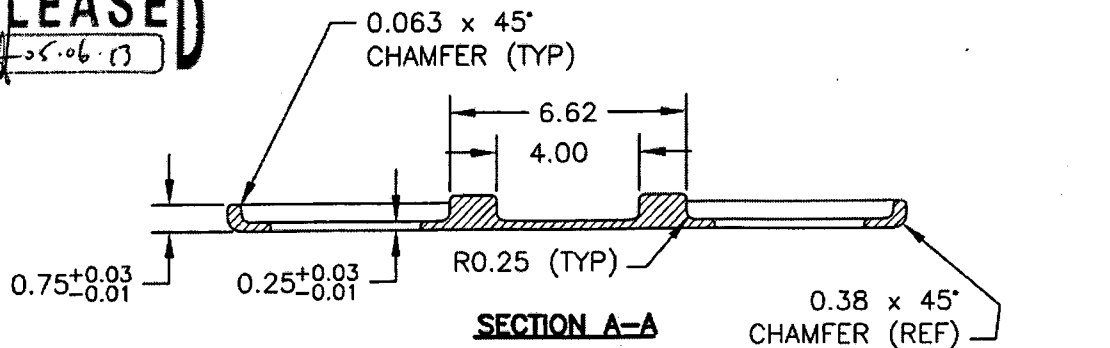
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DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2521	REV. 1 SHEET 2 OF 2
DATE 05.05.20		TITLE 205 BEARPAW	SCALE 1:5

RELEASED
#55.06.13

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